

Work Order ID 164299

Monday, July 17, 2017 9:22:30 AM

164299

Page 1

Item ID: D4941-2L02 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Fwd RH, (Black)
Start Date: 7/21/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-19 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4941	D

110

0.00

110

Purchasing

Purchasing

THERMOFORMING MACHINE

Memo

ISSUE P/O:

SUPPLIER: PLASTECH

MANUFACTURE D4941-2L02 AS PER DWG

C OF C IS REQUIRED

2JUL 19 2017**DAS
13
9-19**

0.00

140

0.00

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Memo

2 x 807-8-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00				②	7-29-06		DAS 9 9-89
Quality Control									
170	Identify as per dwg & Stock Location: <u>S</u>	0.00							
170									
Packaging	Memo	0.00				2			DAS 6 9-89
Packaging									SEP 06 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							17/9/18
Quality Control									

W SEP 06 2017

DAS
21
9-89

SEP 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Page 1

Monday, July 17, 2017 9:22:33 AM

Work Order ID: 164299

164299

Parent Item: D4941-2L02

D4941-2L 02

Parent Item Name: Floor Protector, Fwd RH, (Black)

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev a New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL
DL
Verify DD
IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev. D Revised Dwg. 14/07/25
IPP Rev.E 17.06.13 Now outside process DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-2L02P		Purchased	No			110	Each	0.0000	1	2			
D4941-2L 02P									**				
Floor Protector, Fwd RH, (Black)													

2x SP 7-8-30

MLEXS .125 - F6006-02

(Black)

Batch: _____ qty per kit 4.875 sf

17.07.17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

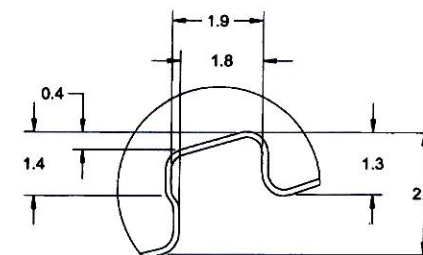
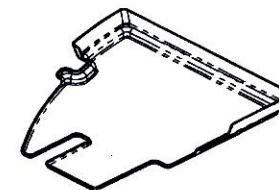


QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

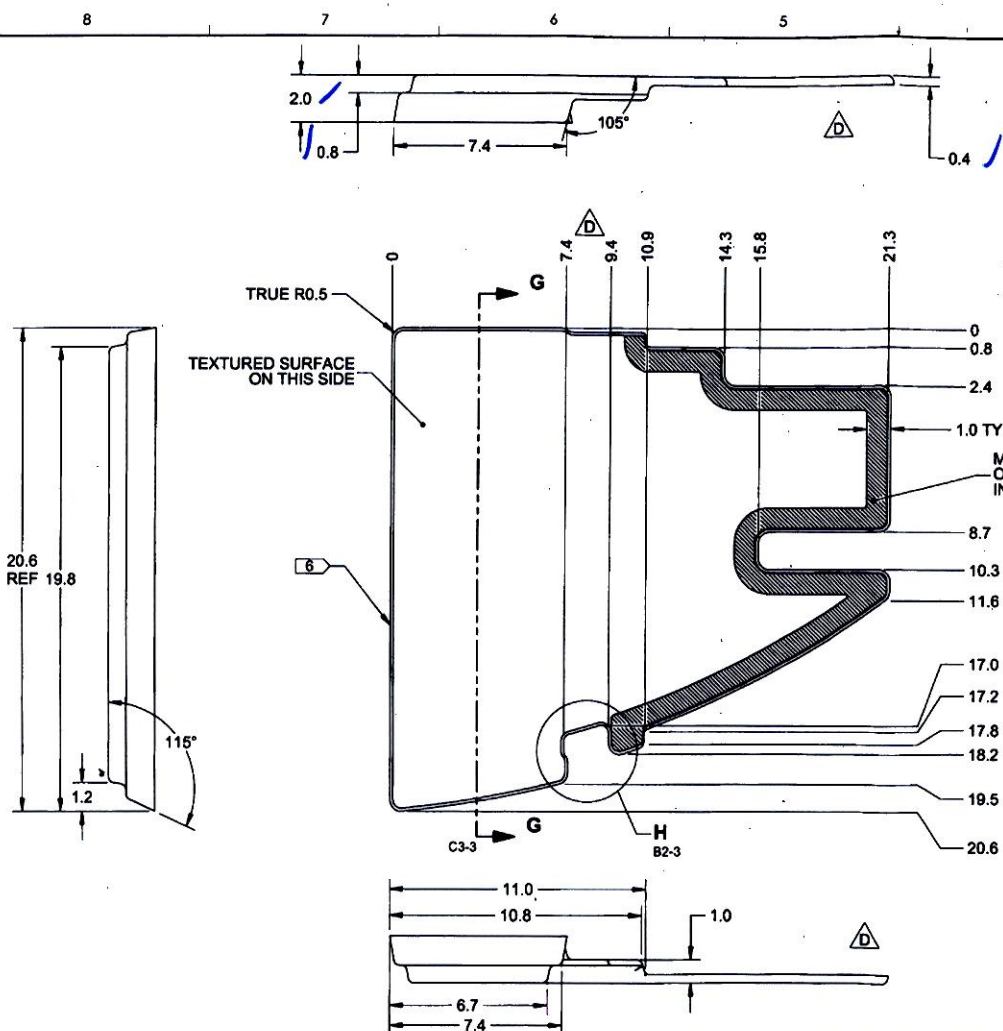
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164299 ULS
170717



DETAIL H
B6-3

SECTION G-G
C6-3

RELEASED
2014-10-08



D4941-2LXX FWD RH FLOOR PROTECTOR

- NOTES:**
1) MATERIAL: SEE TABLE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
7) WEIGHT: 1.5 lbs
8) THERMOFORM PER QSI 022 USING MOLD DT9991
TRIM PER MOLD LEAVING FINISHED EDGES
9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

APPROVED

DESIGN	AK
DRAWN	AK
CHECKED	VS
MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.07.25

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4941	REV. D SHEET 3 OF 5
TITLE CABIN FLOOR PROTECTORS	
SCALE NTS	
COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBARKED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 2 of 9

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$400.00

4	D3136-045P	Window Assembly	7/31/2017	FN	2.00	\$100.00	\$200.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D3136 REV. F

Line Total: \$200.00

5	D4941-1L02P	Floor Protector, Fwd LH, (Black)	7/31/2017		2.00	\$100.00	\$200.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D4941 REV. D
B164297

Line Total: \$200.00

6	D4941-2L02P	Floor Protector, Fwd RH, (Black)	7/31/2017		2.00	\$100.00	\$200.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D4941 REV. D
B164299

Note:

7/19/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order

37108

Carrier Account

CU103666

Sales Order

SO-019288

Incoterms

EX WORKS

Ship Via

FREIGHTCOM INC. -

Payment Method

PPD/CHG

Tracking Number

Item Number - Revision	Description	Quantity Shipped	UOM
D3676-1 - Rev.: D	FULL HEIGHT BUBBLE WINDOW (LH) AS PER DWG D3676 REV. D HS Code: 3920.51.1000 - OTHER Country of Origin : CA	2	EA
D4941-1L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-2L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-3L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-4L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3874-1L02 - Rev.: B	FLOOR PROTECTOR CO-PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3874-2L02 - Rev.: B	FLOOR PROTECTOR PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3774-1 - Rev.: B	SEAT BOTTOM AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3774-3 - Rev.: B	SEAT BACK AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA

SP 17-8-30

2 EA

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3676-1	Qty.	2	Batch #	-001
Description	FULL HEIGHT BUBBLE WINDOW		Material usage	Lot#	891754
Part #	D4941-1L02	Qty.	2	Batch #	
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	-005
Part #	D4941-2L02	Qty.	2	Batch #	-006
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D4941-3L02	Qty.	2	Batch #	-007
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D4941-4L02	Qty.	2	Batch #	-008
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D3874-1L02	Qty.	4	Batch #	-009
Description	FLOOR PROTECTOR CO-PILOT BLACK		Material usage	Lot#	M129722
Part #	D3874-2L02	Qty.	4	Batch #	-010
Description	FLOOR PROTECTOR PILOT BLACK		Material usage	Lot#	M129722
Part #	D3774-1	Qty.	2	Batch #	-011
Description	SEAT BOTTOM		Material usage	Lot#	M137737

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: AUG. 25, 2017 COFC# 005
(Approved QA Signatory)

Page: 1 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3774-3	Qty.	2	Batch #	-012
Description	SEAT BACK	Material usage	1 SHEET	Lot#	M137737
Part #	D4634-1P	Qty.	4	Batch #	-013
Description	FWD CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-3P	Qty.	3	Batch #	-014
Description	MIDDLE CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-5P	Qty.	4	Batch #	-015
Description	AFT CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4635-1	Qty.	3	Batch #	-016
Description	FWD CEILING PANEL, LH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-2	Qty.	3	Batch #	-017
Description	FWD CEILING PANEL, RH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-3	Qty.	3	Batch #	-018
Description	AFT CEILING PANEL, LH	Material usage	OFFCUT	Lot#	M135517
Part #	D4635-4	Qty.	3	Batch #	-019
Description	AFT CEILING PANEL, RH	Material usage	OFFCUT	Lot#	M135517

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN
(Approved QA Signatory)

Date: AUG. 25, 2017 COFC# 005

Page: 2 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com